

Date: Wednesday, 23/04/2008 10:21:51 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PILOT/CO-PILOT STEP, LH (FOLDING)
Job Number	: 38768		
Estimate Number	: 10813		
P.O. Number	:	Part Number	: D412630031
This Issue	: 23/04/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: IIN D412-630
First Issue	: / /	Project Number	: N/A
Previous Run	: 35819	Drawing Revision	: L
	Type : LARGE FAB ASSY	Material	:
Written By	:	Due Date	: 30/04/2008
Checked & Approved By	:	Qty:	2
Comment	: EST. REV. A 05.11.21 NEW ISSUE EC	Um:	Each
	: EST. REV. B 05.12.19 updated pick list EC		
	: EST. REV. C 07.11.12 ecn 1019,no chg EC verified by		
	: DD		

Additional Product

Job Number:



9

Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Socool13



Comment: DOCUMENT CONTROL

Photocopy D412-630 bluefile & type labels per PPP412-630-031 CHG001

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D412-630 p.17

****ensure tension to retract step is 11 to 18 lbs before installing lockwire.****

EPOS/07/28 (2)

MF 08-08-13

3.0	D3463041	Step Weldment Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3463-041	Step weldment	35861

SP

4.0	D3443043	Strut Weldment Assembly
-----	----------	-------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3443-043	Strut ass'y	37089

37089 verified 8/4/23

SO

(37089 KI) AS 08/07/14 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Job Number: 38768

Part Number: D412630031

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 D3443041 Strut Weldment Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description
1 D3443-041 Strut ass'y

Batch

38821 x2

New Batch

AS 28/02/14

6.0 D34439



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description
2 D3443-9 Pin

Batch

30228

SP

7.0 AN4CH3



SS Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description
2 AN4CH3 BOLT
A/R MS20995c41 Lockwire

Batch

103248
m101537

MF 08-08-13

8.0 AN4C14



BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description
1 AN4C14 BOLT

Batch

103248

SP

9.0 D34547



Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description
2 D3454-7 Bushing

Batch

38636 (34)

B 38781 1x6

8/4/23

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number: 38768

Part Number: D412630031

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

AN3104

NUT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN310-4	Nut	<u>105280</u>

SP

11.0

MS24665227

COTTER PIN



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	MS24665-227	COTTER PIN	<u>106043</u>

SP

12.0

D34551

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3455-1	Spacer	<u>28171</u>

SP

13.0

D34651

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3465-1	Washer	<u>33706</u>

SP

14.0

AN3107

NUT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN310-7	Nut	<u>103288</u>

8/4/23

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number: 38768

Part Number: D412630031

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

MS24665302

Cotter Pin



22

Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	MS24665-302	COTTER PIN	M106763

8/4/23

SP

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

****ensure tension to retract step is 11 to 18 lbs ****

8/8/13 12

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

18.0

D34541

Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3454-1	Bushing	33730

SP

19.0

D34543

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3454-3	Bushing	35171

SP

20.0

D34545

Bushing



2X

Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3454-5	Bushing	34842

8/4/24

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 38768

Part Number: D412630031

Job Number:



Seq. #:	Machine Or Operation:	Description :
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21.0	D34551	Spacer
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Comment: Qty.: 6.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
6	D3455-1	Spacer	

28171

34

30226

94

sq

22.0	D34553	Spacer
------	--------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3455-3	Spacer	

1528172

sq

23.0	D3462041	Bracket Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3462-041	Bracket ass'y	

33902

sq

24.0	AN3104	NUT
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	AN310-4	Nut	

1107139

sq

25.0	AN3105	NUT
------	--------	-----



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	AN310-5	Nut	

105280

8/4/24 sq

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number: 38768

Part Number: D412630031

Job Number:



Seq. #: Machine Or Operation: Description :

26.0 AN3C5A Bolt



Comment: Qty.: 3.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
3	AN3-C5A	Bolt	106574

SP

27.0 AN44C12 eyebolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN44-C12	Eyebolt	101771

SP
107923
8/3/21

28.0 AN4C15 BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN4C15	BOLT	103248

SP

29.0 AN5C11 BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN5C11	BOLT	103248

SP

30.0 AN5C15 BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN5C15	BOLT	10121

8/4/24

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: PILOT/CO-PILOT STEP, LH (FOLDING)

Job Number: 38768

Part Number: D412630031

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

AN960C10

WASHER



Comment: Qty.: 7.0000 EACH(s)/Unit Total : 14.0000 EACH(s)

Pick:

Qty	Part Number	Description	Batch
7	AN960C10	Washer	106302

SP

32.0

AN960C516

WASHER



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN960C516	Washer	102842

SP

33.0

MS210433

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
3	MS21043-3	Nut	107288

SP

34.0

MS24665227

COTTER PIN



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	MS24665-227	COTTER PIN	11006043

SP

35.0

MS24665229

COTTER PIN



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	MS24665-229	COTTER PIN	119096

8/4/23

2x

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number: 38768

Part Number: D412630031

Job Number:



Seq. #: Machine Or Operation: Description :

36.0 NAS1515H5 Washer



2x

Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	NAS1515H5	Washer	M100433-18

M106541 24

100064

0 8/7/13
SP

37.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

808100/13 (2 LH)

38.0 PACKAGING 1 PACKAGING RESOURCE #1



(2x)

Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-630-031

Location: 32

PPP Rev: 8

8/8/13

SP

39.0 QC21 FINAL INSPECTION/W/O RELEASE



(2)

Comment: FINAL INSPECTION/W/O RELEASE

808108/14

Job Completion



12 25-08-14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

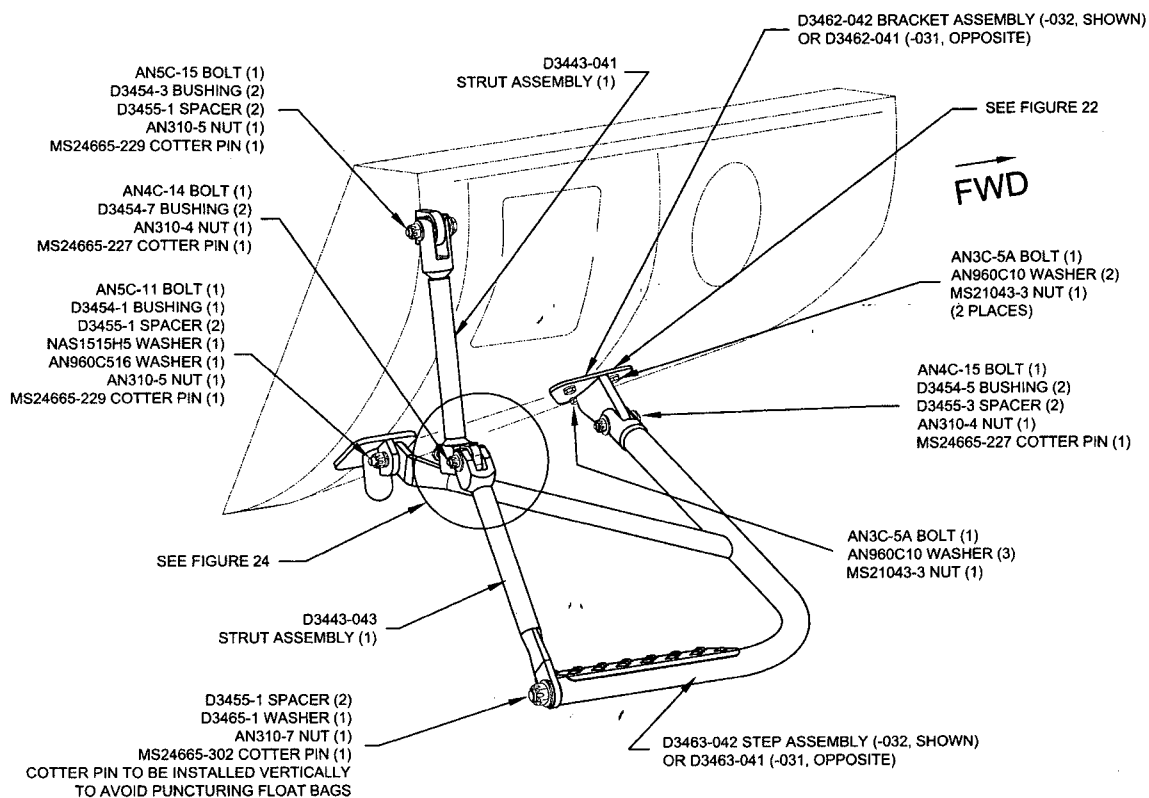


FIGURE 23 – Isometric View D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)
D412-630-031 LH (Opposite)

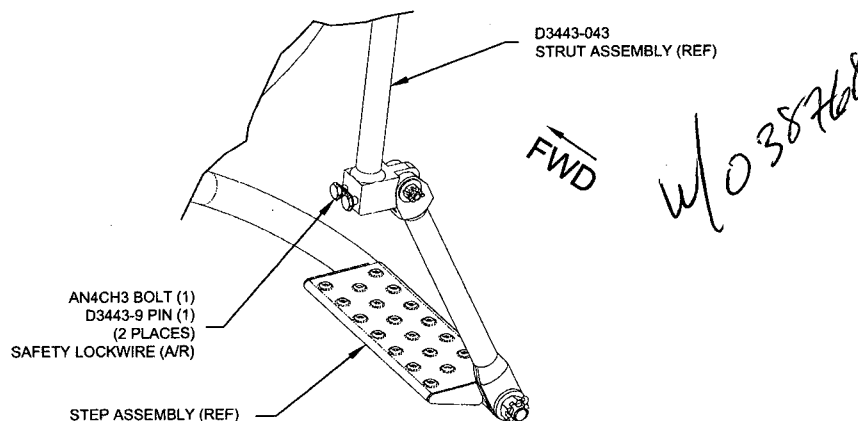


FIGURE 24 – Detail Safety Wiring, D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)
D412-630-031 LH (Opposite)

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Revision: L
Date: 07.09.30

Date: Wednesday, 28/05/2008 10:11:14 AM
 User: Julie Lecocq

Process Sheet

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Prsht Rev. : NC	Project Number : N/A
First Issue : 23/04/2008 Type : SMALL /MED FAB	Drawing Revision : L
Previous Run : 35819	Material :
Written By :	Due Date : 30/04/2008 Qty: 2 Um: Each
Checked & Approved By :	
Comment : EST. REV. A 05.11.21 NEW ISSUE EC	
EST. REV. B 05.12.19 updated pick list EC	
EST. REV. C 07.11.12 ecn 1019,no chg EC verified by	
DD	

Additional Product

REFERENCE ONLY

Job Number: 

Seq. #: **Machine Or Operation:** **Description :**

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy D412-630 bluefile & type labels per PPP412-630-031 CHG001

JUD 08.5.28

2.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D412-630 p.17

****ensure tension to retract step is 11 to 18 lbs before installing lockwire.****

3.0 D3463041 Step Weldment Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3463-041	Step weldment	

4.0 D3443043 Strut Weldment Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3443-043	Strut ass'y	